

Date: Thursday, 23/04/2009 1:59:42 PM  
User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: WEB		
<b>Job Number</b>	: 47409			<b>Part Number</b>	: D2739		
<b>Estimate Number</b>	: 10498			<b>Drawing Number</b>	: D2739 REV D		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 23/04/2009	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: D		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / /	<b>Type</b>	: SKIDTUBES	<b>Due Date</b>	: 30/04/2009	<b>Qty:</b>	6
<b>Previous Run</b>	: 47291			<b>Um:</b>	: Each		
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: <u>7/009.04.23</u>						
<b>Comment</b>	: Est Rev: C 02.11.28 Reformat KJ						
	Est Rev: D 06-03-21 As Per Rev C JLM						
	Est Rev: E 07-07-28 As per Rev D JLM Verified By:						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
		
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)	
	Extrusion 'I Beam' thin	(6)
	Pick:	
	Qty Part Number Description Batch	
	1 D2600-5 Web <u>B-38589</u>	
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
		
		
	Comment: LANDING GEAR RESOURCE 1	
	1-Cut D2600-5 to length as per Dwg D2739.	
	2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739	
	3-Use uni-bit to open holes to finish size as per Dwg D2739.	
	4-Bevel Fwd end of extrusion and Deburr holes and ends.	
	5-Dburr	(6)
3.0	QC5	INSPECT WORK TO CURRENT STEP
		
		
	Comment: INSPECT WORK TO CURRENT STEP	(6)
		AE 09-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 47409		Part Number: D2739
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
4.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>Aug 9-4-24 6</i>		
5.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
<b>Comment:</b> INSPECT POWDER COAT/CHEMICAL CONVERSION <i>9-4-27</i>		
6.0	PACKAGING 1 	PACKAGING RESOURCE #1 
<b>Comment:</b> PACKAGING RESOURCE #1 Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web. Identify and Stock Location: <i>L-G Aug 9-4-27 6</i>		
7.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>09/04/27</i>
<b>Comment:</b> FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>U 09-04-27</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

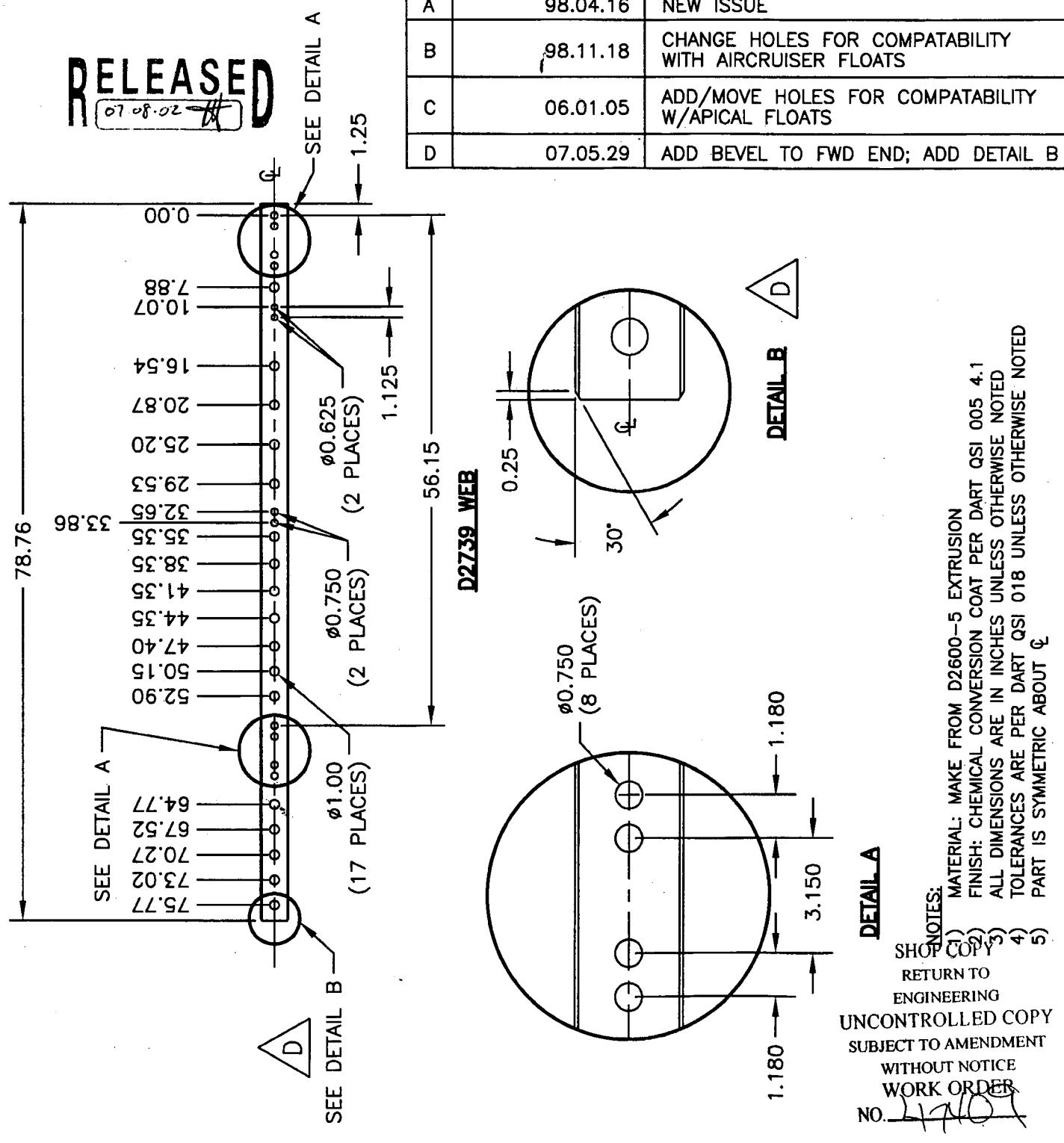
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**DART**

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2739
DATE 07.05.29		TITLE WEB
		SCALE 1:15
A	98.04.16	NEW ISSUE
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B

**RELEASED**  
20.80.70NOTES:  
1) MATERIAL: MAKE FROM D2600-5 EXTRUSION  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) PART IS SYMMETRIC ABOUT  $\frac{1}{4}$ UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 11707

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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